

76451

Monday, November 14, 2011 3:05:37 PM

N900040100

Setup Start *NS1*

Stop *NS2*

12

12

Customer:

Run Start *NR1*

Date:

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Draw Nbr	Revision Nbr	
D2573	Rev E	

0,00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 71457 Double check by: smf 1-Machine Step
No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine
Step No 2 per Folio FA051 and inspect per attached Dimension Sheets3-
Machine Step No 3 per Folio FA051 and insp

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76451

76451

Page 2

Monday, November 14, 2011 3:05:38 PM

Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Aft Out 205
 Start Date: 11/14/2011 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 11/30/2011 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC8- Inspect parts - second check 0.00

130

QC Memo 0.00
 Quality Control

Just 11.11.30

12 Ø

140 Chemical Conversion Coat per QSI005 4.1 0.00

140

HandFinish Memo 0.00
 Hand Finishing

12x Ø m-11/11/30

150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

150

Powdercoat Memo 0.00
 Powder Coating START TIME: 8-10 OVEN TEMPERATURE:
 FINISH TIME: 8-40

12x Ø m-11/12/01

M118439

32001

8-40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 76451***76451***

Page 3

Monday, November 14, 2011 3:05:38 PM

Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Aft Out 205
Start Date: 11/14/2011 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 11/30/2011 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				12x COUNTED	0	11/12/11	
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>434</u> Memo	0.00 0.00						11/12/11	(12)
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/12/11	

mf
11-12-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, November 14, 2011 3:05:42 PM

Page 1

Work Order ID: 76451

76451

Parent Item: D2573

D2573

Parent Item Name: Saddle, Aft Out 205

Start Date: 11/14/2011

Required Date: 11/30/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: 1 As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-007		Manufactured	No			100	Each	45.0000	1	12			
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D6101-007

Saddle Billet

Location

Loc Qty

Loc Code

MAT

8

71722

8

MAT042

2

72228

2

MAT045

35

65383

1

65954

4

70680

6

→ 73421

4

→ 74781

20

4
8

on 11/13/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 76451
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.001	8.001	8.001		
F	0.490	0.510		.502	.500	.500	.501		
G	0.257	0.262		.257	.259	.259	.259		
H	0.375	0.380		.375	.377	.377	.377		
I	0.490	0.510		.502	.502	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.567	.567	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.126	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.250	.249	.250		
S	0.115	0.135		.130	.127	.128	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.228	3.228	3.228		
V	0.230	0.250		.242	.237	.237	.237		
W	0.115	0.135		.126	.130	.129	.126		
X	0.308	0.313		.311	.310	.310	.310		
Y	0.760	0.765		.763	.764	.764	.764		
Z	0.352	0.372		.361	.354	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.620	.620	.619	.619		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.246	.247	.247		
AE	1.500	1.520		1.513	1.5125	1.5125	1.5135		
AF	0.115	0.135		.120	.125	.120	.125		
AG	0.240	0.280		.260	.265	.275	.275		
AH	0.240	0.260		.250	.248	.248	.247		
AI	2.000	2.020		2.000	2.003	2.003	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>Re/omf</i>
Date: <i>11/11/26</i>

Audited by: <i>[Signature]</i>
Date: <i>11.11.30</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 76451
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.001	8.001	8.001		
F	0.490	0.510		.501	.500	.500	.500		
G	0.257	0.262		.251	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.503	.501	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.570	.569	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.257	.250	.257		
S	0.115	0.135		.126	.127	.127	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.229	3.229	3.229	3.229		
V	0.230	0.250		.236	.237	.237	.237		
W	0.115	0.135		.130	.126	.126	.126		
X	0.308	0.313		.310	.310	.311	.311		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.364	.364	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.619	.619	.619	.619		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.248	.247	.247		
AE	1.500	1.520		1.513	1.5135	1.513	1.5135		
AF	0.115	0.135		.126	.127	.127	.127		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.247	.249	.247	.247		
AI	2.000	2.020		2.003	2.004	2.003	2.0033		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>cmk</i>
Date: 11/11/28

Audited by: <i>[Signature]</i>
Date: 11.11.30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 76451
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				A9	210	211	A12		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		.501	.501	.501	.501		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.501	.501	.501	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
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P	0.115	0.135		.126	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.129	.129	.129	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.228	3.228	3.228	3.228		
V	0.230	0.250		.235	.235	.235	.235		
W	0.115	0.135		.128	.128	.128	.128		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.364	.364	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.619	.619	.619	.619		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.246	.246	.246		
AE	1.500	1.520		1.515	1.515	1.515	1.515		
AF	0.115	0.135		.127	.127	.127	.127		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.246	.246	.246	.246		
AI	2.000	2.020		2.005	2.005	2.005	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>RF</i>
Date: 11/11/28

Audited by: <i>[Signature]</i>
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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